












Date: Monday, 25/06/2007 3:01:14 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG EXTRUSION
Job Number	: 33135		
Estimate Number	: 10326		
P.O. Number	: <i>N/A</i>	Part Number	: D27317
This Issue	: 25/06/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2731 REV B
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 32388	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 02/07/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	24 Um: Each
Comment	: Est D 00.05.19 Added inspect level 8, removed P/O powder coating EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D2423	Lug Extrusion	
			
Comment: Qty.: 0.0717 f(s)/Unit Total : 1.7212 f(s) Lug Extrusion D2423 Batch: <i>30062</i>			
2.0	BAND SAW	BAND SAW	
			
Comment: BAND SAW Cut D2423 extrusion to .82" Batch <i>30062</i>			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
<p><i>PG</i> <i>Issue P.O 4058 C207100607</i> <i>12</i></p> <p>Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per folio D2731-7. 2-Check for crack while loading into the machine. 3-Tumble 4-Deburr any rough edges after tumbling</p> <p><i>BLH00001</i> <i>machine per June D2731 Rev B.</i></p>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<p><i>RG</i> <i>Receive + Inspect for transit damage</i></p> <p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>07/06/08</i></p>			
5.0	QC5	SECOND CHECK	
			
<p><i>07 06 26</i></p> <p>Comment: SECOND CHECK</p>			

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 07/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-l

12x
06
07/07/27

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPARY PAINT

DELFLEET BLUE

CLEAR DELFLEET

12

ISSUE P.O TO ATELIER DEBOSELAGE

4058 0207/08/07/12

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT POWDER COAT

2007-03-12

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/4 59 12x

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

72
2007/07/04

Job Completion



u 07-07-04

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries